

Work Order ID 68958

Tuesday, April 26, 2011 12:58:55 PM

Page 1

Item ID: D3681-1

Accept

Setup Start

Revision ID:

Stop

Item Name: Spacer

Start Date: 4/26/2011 Start Qty: 20.00

Required Date: 4/29/2011 Req'd Qty: 20.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date: 11-04-26

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D3681

Rev A

100

0.00



Hardinge CNC LATHE SMALL

Hardinge

Memo

0.00

Hardinge CNC Lathe Small

1-TURN AS PER FOLIO FA711 & DWG D3681

FOLIO REV: 1

DWG REV: 11/4/26

2-DEBURR AS REQUIRED

110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

120

0.00



QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

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Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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125

0.00



Skidtubes

Memo

0.00

Skidtubes

I - clean crossbolt spacer with ultra bright aluminum cleaner before storing.

20 0 BE 11/04/28

130

0.00



Packaging

Identify as per dwg & Stock Location: LG

Memo

0.00

Packaging

STOCK IN SKIDTUBE CELL

20 0 BE 11/04/28

140

0.00



QC

QC21 - Final Inspection - Work Order Release

Memo

0.00

Quality Control

11/4/28 J
ME
11-04-28

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Picklist Print

Tuesday, April 26, 2011 12:59:02 PM

Page 1

Work Order ID: 68958



Parent Item: D3681-1



Parent Item Name: Spacer

Start Date: 4/26/2011

Required Date: 4/29/2011

Start Qty: 20.00

Required Qty: 20.00

Comments: IPP Rev A new issue 07-10-30 DD verified by:EC
IPP Rev:B Ecn 1056 Rev A dwg DD IPP Rev:C add
seq 125 DD 10.05.03 verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M6061T6T0.3125W.05
8

Purchased

No

100

f

191.6390

0.34

7.157895



ALUM TUBE .3125 x .058w



SA 11/4/26

Location

Loc Qty

Loc Code

MAT013

191.639

116793

1.667

116939

93.972

— 117400

96

7.1 pt

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

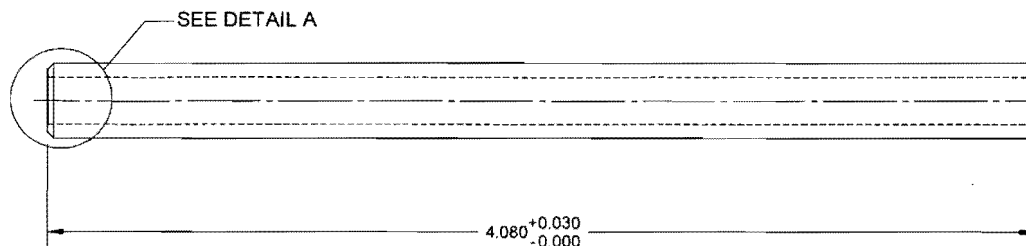
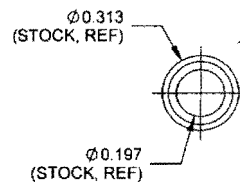
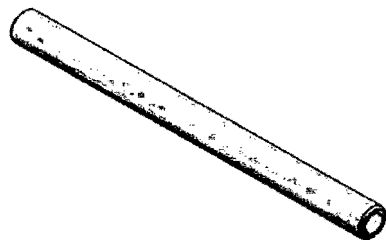
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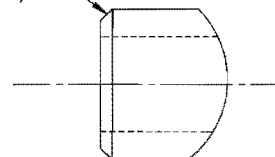
NOTE: Date & initial all entries



D3681-1 SPACER

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 68958

0.025 X 45°
CHAMFER
(TYP)



DETAIL A
(SCALE 4 : 1)

RELEASED
07-11-08

NOTES:

- 1) MATERIAL: 6061-T6 OR 6061-T62 ALUMINUM TUBING 0.313" OD X 0.058" WALL
PER WW-T-700/6 OR AMS 4080 OR AMS 4082
OR QQ-A-200/8 OR QQ-A-225/8
(REF. DART SPEC. M6061T6T0.313W.058)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.02 lbs

A		NEW ISSUE		DC	07.11.08
REV.		DESCRIPTION		BY	DATE
DESIGN	SC	DART AEROSPACE USA, INC. PORT HADLOCK, WA			
DRAWN	SC				
CHECKED	MD	DRAWING NO. D3681		REV. A	
MFG. APPR.	ED				SHEET 1 OF 1
APPROVED	W	TITLE SPACER			SCALE 2:1
DE APPR.	#				
DATE	07.11.08				

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